



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

S.000585

D3884-2
Job Sheet 165376



Part No: D3884-2

Job Qty: 8 ea

Part Name: Saddle, Inside RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D3884-2 Saddle, Inside RH	DWG REV C IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD VERF:JLM		0.000	
D6101-017 Saddle Billet	DWG REV B IPP RevA: New issue DD verified by:EC		0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	8 Ea	10/30/17	0.00	0.00	Start up container	
100	CNC Vertical Machining	8 pcs	10/30/17	0.31	14.04	HAAS 1	
110	QC	8 pcs	10/30/17	0.00	0.00	QC2	
120	QC	8 pcs	10/30/17	0.00	0.00	QC8	
130	HandFinish	8 pcs	10/30/17	0.00	0.75	HandFinish1	
140	Powdercoat	8 pcs	10/31/17	0.00	0.41	Powdercoat1	
150	QC	8 pcs	10/31/17	0.00	0.00	QC3	
160	Packaging	8 pcs	10/31/17	0.00	0.00	Packaging3	
170	QC21-SA	8 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA819
and inspect per Dimension Sheets
140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-017	8	0	0	0

Part Specifications

Specifications could not be found.



S000585



Saddle, Inside RH

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO: D3884-2
Revision:
Operation: QC21-SA
Quantity: 8
Change No:

Mfg Date: 10/15/17

Job No: 165376

Work Order ID 165376

Monday, August 21, 2017 2:46:06 PM

165376

Page 1

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Inside RH
Start Date: 9/6/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 9/12/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: **DAS** 21 **9-89** Date: **AUG 22 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3884	C

100

1.96

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

4.38

HAAS CNC vertical machine #1

Program Batch No. _____

Double check by: _____

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

8

φ

SBL
17/10/16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.08

Quality Control

8

φ

SBL
17/10/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Work Order ID 165376

Monday, August 21, 2017 2:46:06 PM

165376

Page 3

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Inside RH
Start Date: 9/6/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 9/12/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)*** <i>M 1380W.</i> ***DO NOT MASK INSIDE FLANGE SURFACE*** START TIME: <i>11:05.</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>11:35.</i>	0.00 0.64				<i>8</i>	<i>0</i>	<i>17-10-24</i>	<i>38</i> <i>38</i> <i>38</i>
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.08				<i>8</i>			<i>38</i> <i>38</i> <i>38</i>

OCT 25 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Monday, August 21, 2017 2:46:06 PM

Item ID: D3884-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop ***NS2***

Item Name: Saddle, Inside RH

Start Date: 9/6/2017 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 9/12/2017 **Req'd Qty:** 8.00 ***g***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number**Insp.
Stamp**

160

Identify as per dwg & Stock Location:_____

0.00

160

Packaging

Memo

0.08

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.80

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Picklist Print

Monday, August 21, 2017 2:46:10 PM

Page 1

Work Order ID: 165376

165376

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inside RH

Start Date: 9/6/2017

Required Date: 9/12/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017		Manufactured	No			100	Each	17.0000	1	8			
D6101-017									**				
Saddle Billet													

Location

Loc Qty

Loc Code

MAT046

17

155443

7

162575

10

8

17/10/16 SBL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : 					

DART AEROSPACE LTD		Work Order: 165376
Description: Saddle, Inboard, RH		Part Number: D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2,875	2,875	2,875	2,875		
B	1.433	1.443		1,438	1,438	1,438	1,438		
C	0.638	0.658		0,640	0,643	0,643	0,641		
D	3.895	3.905		3,900	3,900	3,900	3,900		
E	0.257	0.262		0,258	0,258	0,258	0,258		
F	0.605	0.625		0,610	0,610	0,610	0,610		
G	1.120	1.130		1,125	1,125	1,125	1,125		
H	2.245	2.255		2,250	2,250	2,250	2,250		
I	2.000	2.020		2,000	2,000	2,000	2,000		
J	0.140	0.175		0,160	0,165	0,158	0,158		
K	1.265	1.285		1,265	1,265	1,265	1,265		
L	0.115	0.135		0,125	0,125	0,125	0,125		
M	0.240	0.260		0,250	0,250	0,250	0,251		
N	0.110	0.140		0,125	0,130	0,135	0,135		
O	0.240	0.260		0,249	0,250	0,250	0,250		
P	2.826	2.886		2,859	2,858	2,858	2,855		
Q	0.178	0.198		0,188	0,188	0,188	0,188		
R	0.140	0.165		0,160	0,152	0,150	0,152		
S	0.720	0.780		0,750	0,750	0,750	0,755		
T	1.220	1.280		1,255	1,255	1,255	1,255		
U	1.245	1.255		1,250	1,250	1,250	1,250		
V	5.990	6.010		6,001	6,001	6,002	6,002		
W	2.495	2.505		2,500	2,500	2,500	2,500		
X	0.490	0.510		0,500	0,500	0,500	0,499		
Y	0.020	0.040		0,025	0,025	0,025	0,022		
Z	0.313	0.318		0,313	0,313	0,313	0,313		
AA	0.760	0.765		0,760	0,760	0,760	0,760		
AB	0.215	0.220		0,220	0,219	0,219	0,219		
AC	0.316	0.321		0,316	0,316	0,316	0,316		
AD	1.745	1.755		1,750	1,750	1,750	1,750		
AE	0.990	1.010		0,998	0,998	0,998	1,000		
AF									
Accept/Reject									

Measured by: SBL 01
Date: 17/10/16

Audited by: [Signature]	DAC
Date: 17-10-24	CS
	8-01

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	[Signature]

DART AEROSPACE LTD		Work Order:	165376
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#5	#6	#7	#8		
A	2.870	2.880		2,877	2,875	2,875	2,875		
B	1.433	1.443		1,436	1,438	1,438	1,438		
C	0.638	0.658		1,645	1,644	1,642	1,644		
D	3.895	3.905		3,900	3,900	3,900	3,900		
E	0.257	0.262		1,258	1,258	1,258	1,258		
F	0.605	0.625		1,610	1,612	1,610	1,612		
G	1.120	1.130		1,125	1,125	1,125	1,125		
H	2.245	2.255		2,250	2,250	2,250	2,250		
I	2.000	2.020		2,000	2,000	2,000	2,000		
J	0.140	0.175		1,137	1,138	1,139	1,135		
K	1.265	1.285		1,265	1,267	1,267	1,267		
L	0.115	0.135		1,125	1,125	1,125	1,125		
M	0.240	0.260		1,250	1,250	1,250	1,250		
N	0.110	0.140		1,135	1,135	1,135	1,135		
O	0.240	0.260		1,249	1,250	1,250	1,250		
P	2.826	2.886		2,855	2,860	2,854	2,855		
Q	0.178	0.198		1,188	1,188	1,188	1,188		
R	0.140	0.165		1,152	1,151	1,151	1,152		
S	0.720	0.780		1,757	1,758	1,752	1,753		
T	1.220	1.280		1,240	1,257	1,258	1,255		
U	1.245	1.255		1,248	1,248	1,249	1,248		
V	5.990	6.010		6,002	6,002	6,003	6,003		
W	2.495	2.505		2,499	2,500	2,500	2,500		
X	0.490	0.510		1,505	1,505	1,499	1,500		
Y	0.020	0.040		1,025	1,025	1,025	1,025		
Z	0.313	0.318		1,313	1,313	1,313	1,313		
AA	0.760	0.765		1,760	1,760	1,760	1,760		
AB	0.215	0.220		1,219	1,218	1,218	1,218		
AC	0.316	0.321		1,316	1,316	1,316	1,316		
AD	1.745	1.755		1,750	1,750	1,750	1,750		
AE	0.990	1.010		1,002	1,000	1,000	1,001		
AF									
Accept/Reject									

Measured by:	SBLol
Date:	17/10/16

Audited by:	B. C. DAS
Date:	17-10-24

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

8

7

6

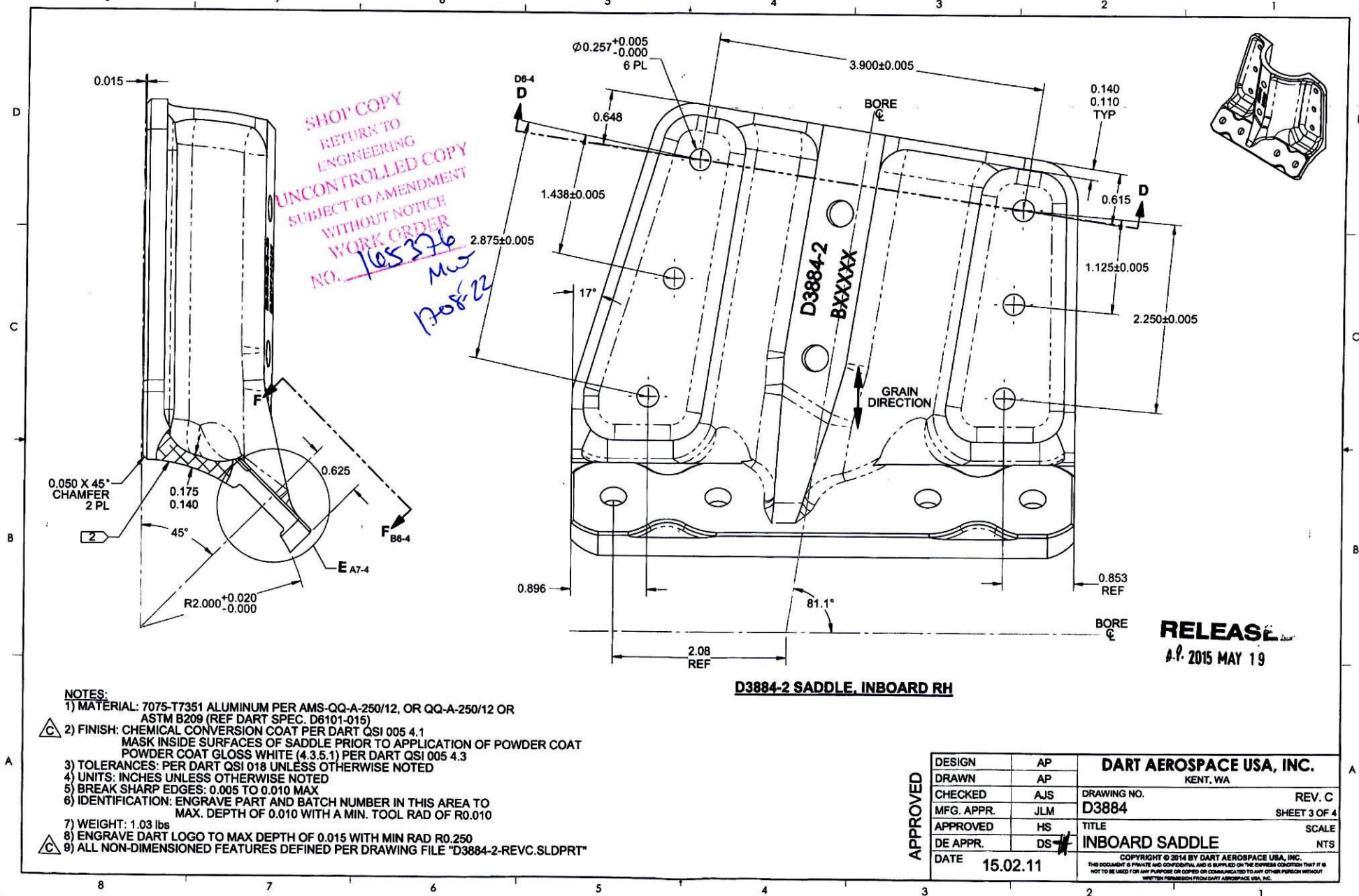
5

4

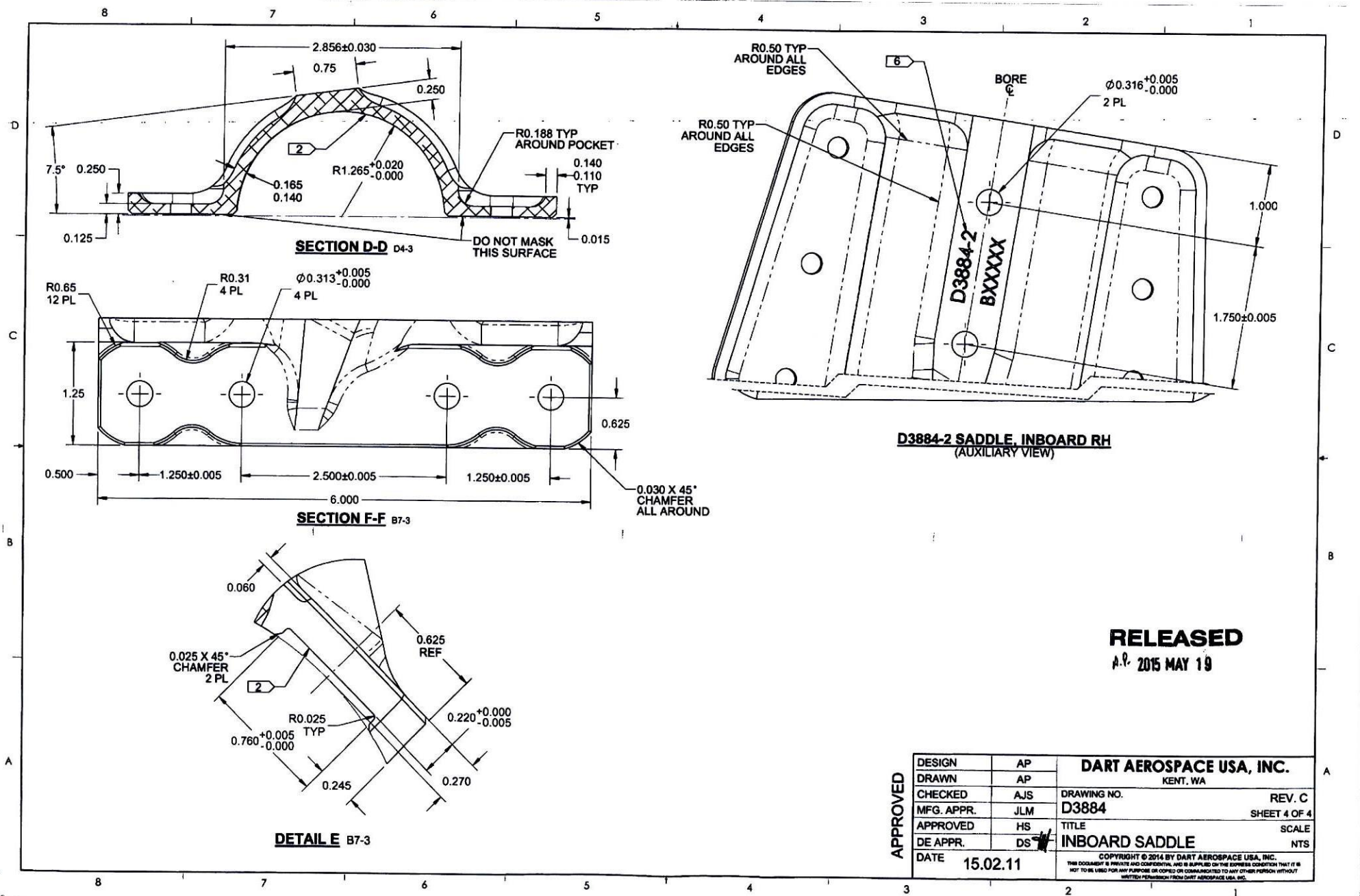
3

2

1



RELEASE
15 MAY 19



RELEASED
A.P. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
	DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

